

Date: Monday, 10/30/2006 4:15:19 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE		
Job Number	: 29232	Part Number	: D29331		
Estimate Number	: 10833	Drawing Number	: D2933 REV B		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 10/30/2006	S.O. No.	: N/A		
Prsht Rev.	: NC	Drawing Revision	: B		
First Issue	: N/A	Material	: N/A		
Previous Run	: 28860	Due Date	: 11/30/2006	Qty:	8 Um: Each
Written By					
Checked & Approved By					
Comment	: Est: B00.06.26 New DWG rev (mpp 2069) EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	7075-T7351 2X6X6.25	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: 1325343	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/15
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/15	2	Tool radius for flange pocketing is R0.188 instead of R0.25. 0.30.	QP 06/11/15 per QSI 042	Use R0.188 per marked up dwg. See attached DS email	SD 06/11/15	PP 06/11/15	QP 06/11/15 per QSI 042	DD 06/11/15

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 4:15:19 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 29232

Part Number: D29331

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 06/11/22

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 POWDER COATING POWDER COATING



M102391

4.0

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YL 06/11/27 X 8

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

YL 4/4/27 ⑧

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY13

YL 4/4/27 ⑧

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

YL 4/4/27 ⑧

Job Completion



YL 6/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	29232
Description: 206 Saddle, Inboard, Left side				Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.125	.125	.125		
B	0.100	0.140		.127	.125	.125	.125		
C	0.100	0.140		.113	.120	.121	.122		
D	0.210	0.230		.220	.220	.219	.219		
E	1.245	1.255		1.250	1.250	1.258	1.260		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.499	2.499		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		.120	.120	.119	.120		
O	0.540	0.560		.550	.551	.551	.550		
P	0.490	0.510		.500	.508	.499	.499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.498	2.498	2.495		
S	0.240	0.270		.253	.253	.253	.253		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.315	.315	.315	.315		
X	1.125	1.145		1.134	1.134	1.133	1.133		
Y	1.565	1.585	DT8695 A/B	1.570	1.571	1.575	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<u>SD</u>	Audited by:	<u>J.L</u>
Date:	<u>06.11.15</u>	Date:	<u>06/11/15</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	<u>JLM</u> <u>JL</u>

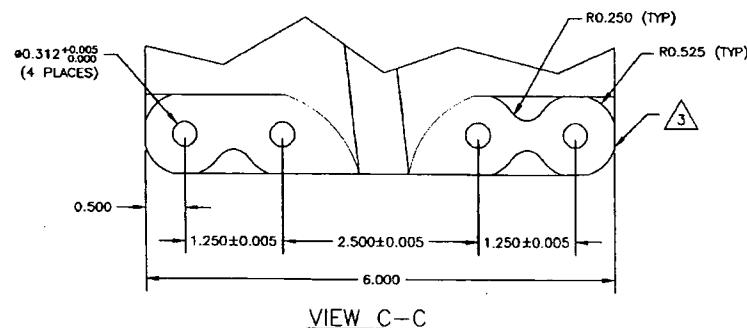
DART AEROSPACE LTD				Work Order:	29232
Description: 206 Saddle, Inboard, Left side				Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

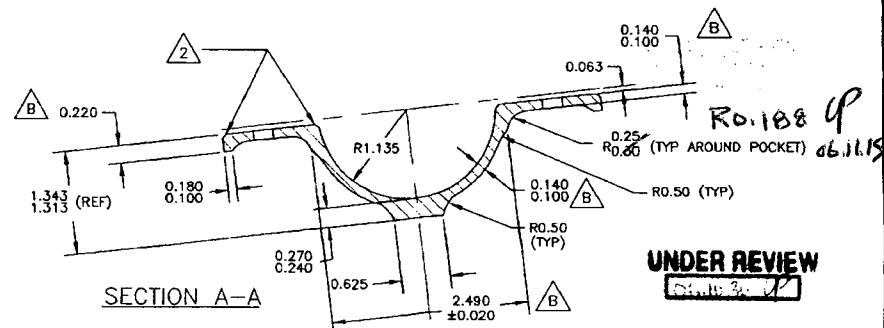
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.130	0.130	0.128	0.128		
B	0.100	0.140		0.130	0.131	0.131	0.128		
C	0.100	0.140		0.129	0.127	0.127	0.130		
D	0.210	0.230		0.217	0.218	0.219	0.215		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.256	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.237	0.238	0.238		
N	0.100	0.140		0.118	0.119	0.120	0.117		
O	0.540	0.560		0.552	0.552	0.551	0.547		
P	0.490	0.510		0.502	0.502	0.502	0.502		
Q	3.715	3.725		3.721	3.721	3.718	3.720		
R	2.470	2.510		2.499	2.490	2.495	2.492		
S	0.240	0.270		0.255	0.254	0.254	0.255		
T	0.100	0.180		0.143	0.140	0.140	0.138		
U	1.625	1.635		1.630	1.628	1.628	1.628		
V	1.362	1.372		1.368	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.132	1.133	1.133	1.132		
Y	1.565	1.585	DT8695 A/B	1.573	1.575	1.575	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	S.A. / aml	Audited by:	J.L.
Date:	06/11/13	Date:	06/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	JLM



VIEW C-C

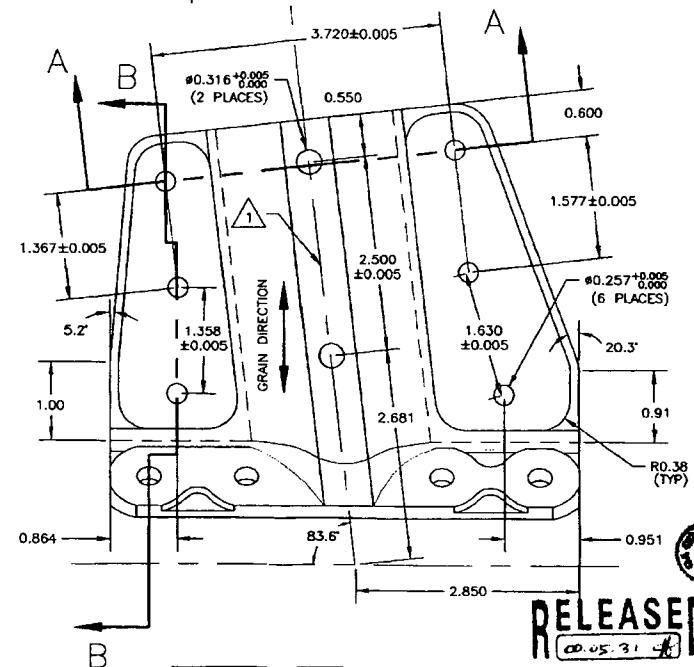
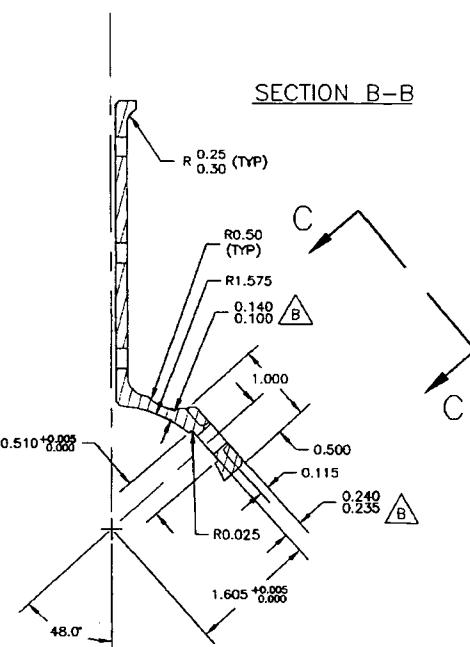


UNDER REVIEW
01.16.31.10

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QC-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



RELEASED
00.05.31.10

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B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO.
DATE		REV. B D2933 SHEET 1 OF 1
00.05.29		TITLE SCALE SADDLE INSIDE 2:3

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WORK ORDER
NO. 29232

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188
since the tooling has been changed long time ago, and apparently they have been machining those radiiuses to
0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the
changes.

Serge

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No virus found in this incoming message.
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Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

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